

Date: Tuesday, 10/23/2007 3:10:27 PM  
 User: Kim Johnston

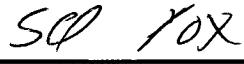
## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ASPIRATOR	
Job Number	: 35322		Part Number	: D2000111	
Estimate Number	: 12425		Drawing Number	: D2000-111 REV A1	
P.O. Number	:		Project Number	: N/A	
This Issue	10/23/2007	S.O. No.	Drawing Revision	: A1	
Prsht Rev.	: NC		Material	:	
First Issue	1 /	Type	PURCHASED PARTS	Due Date	11/15/2007
Previous Run	: 27332		Qty:	10	Um: Each
Written By	:		Comment	: Est Rev A New Issue 06-05-31 JLM	
Checked & Approved By	: <u>10/23/07</u>				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>4888</u> For D2000-111 Spin as per Dwg D2000-111 Possible Supplier: SIEG <u>C20710124</u>  Material release note is required		
2.0	D2000111S	Aspirator - Inner Core
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Aspirator - Inner Core		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <u>7/11/07</u>  <u>SP 10X</u> 		
4.0	QC6	DIMENSIONAL CHECK
		 <u>100-05-06</u> 
Comment: DIMENSIONAL CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill as per Dwg D2000 Deburr <u>FF 08-05-21</u> 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-11-19	1.0	Upon inspection, the parts were found to be non-conforming to the drawing. O.D. is too small, and I.D. is too large.	Initial Chief Eng QSI/aut2	(return for replacement as per NCRB 250) Not necessary, Mating parts in Ass'y is A1			QSI/aut2	11-11-19

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 35322

Part Number: D2000111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



8 08/05/21 40

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



10x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 162

8/5/21

SD

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/22 40

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-22

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

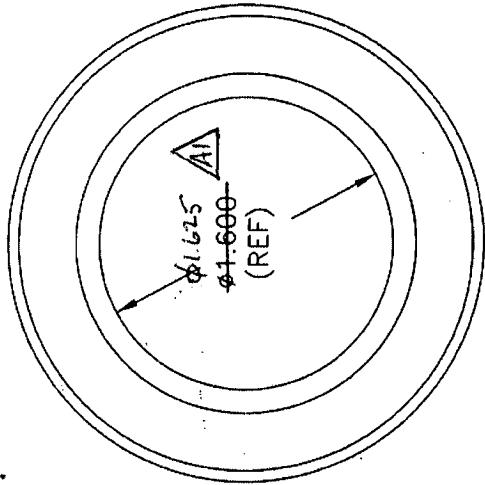
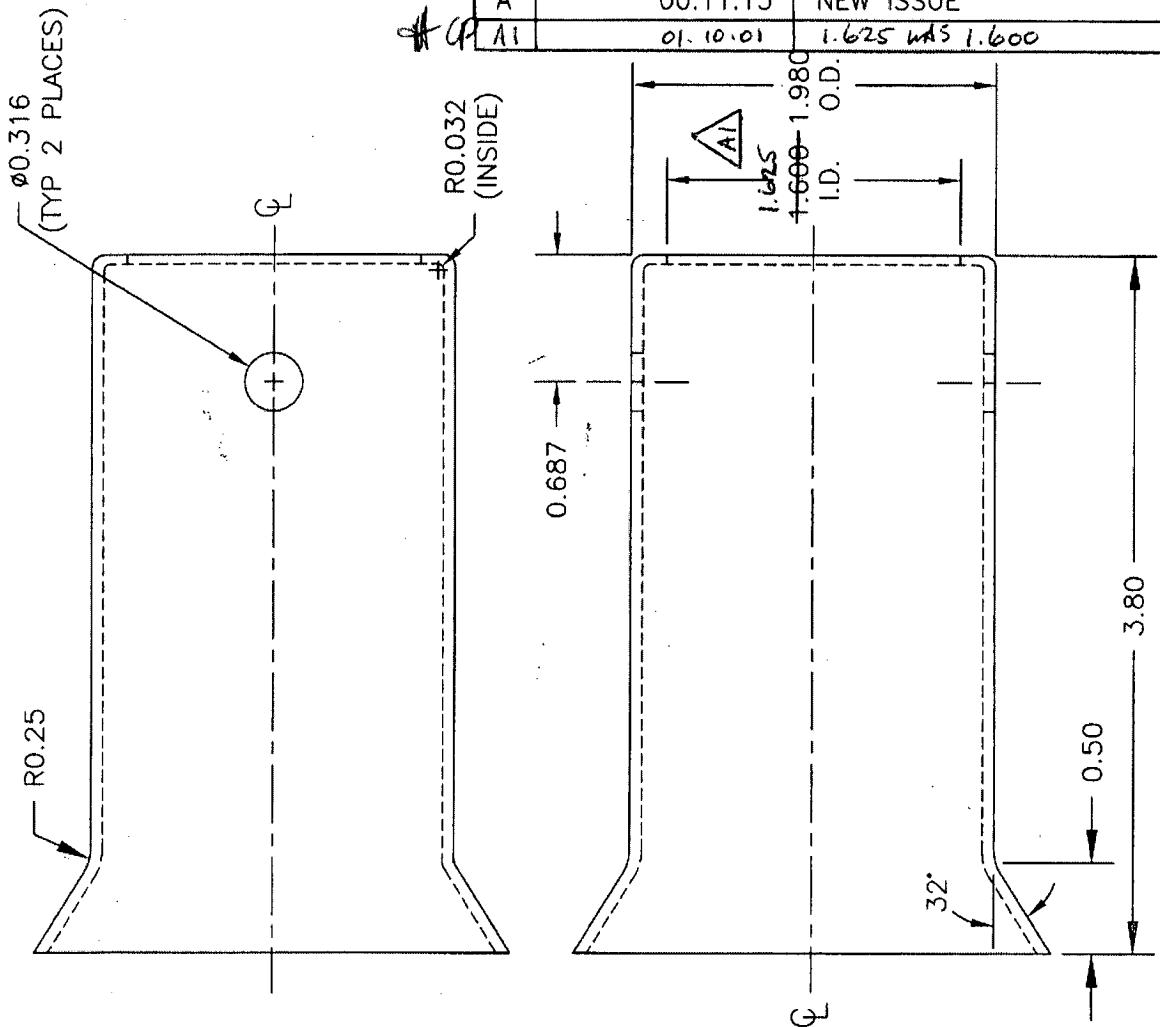
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



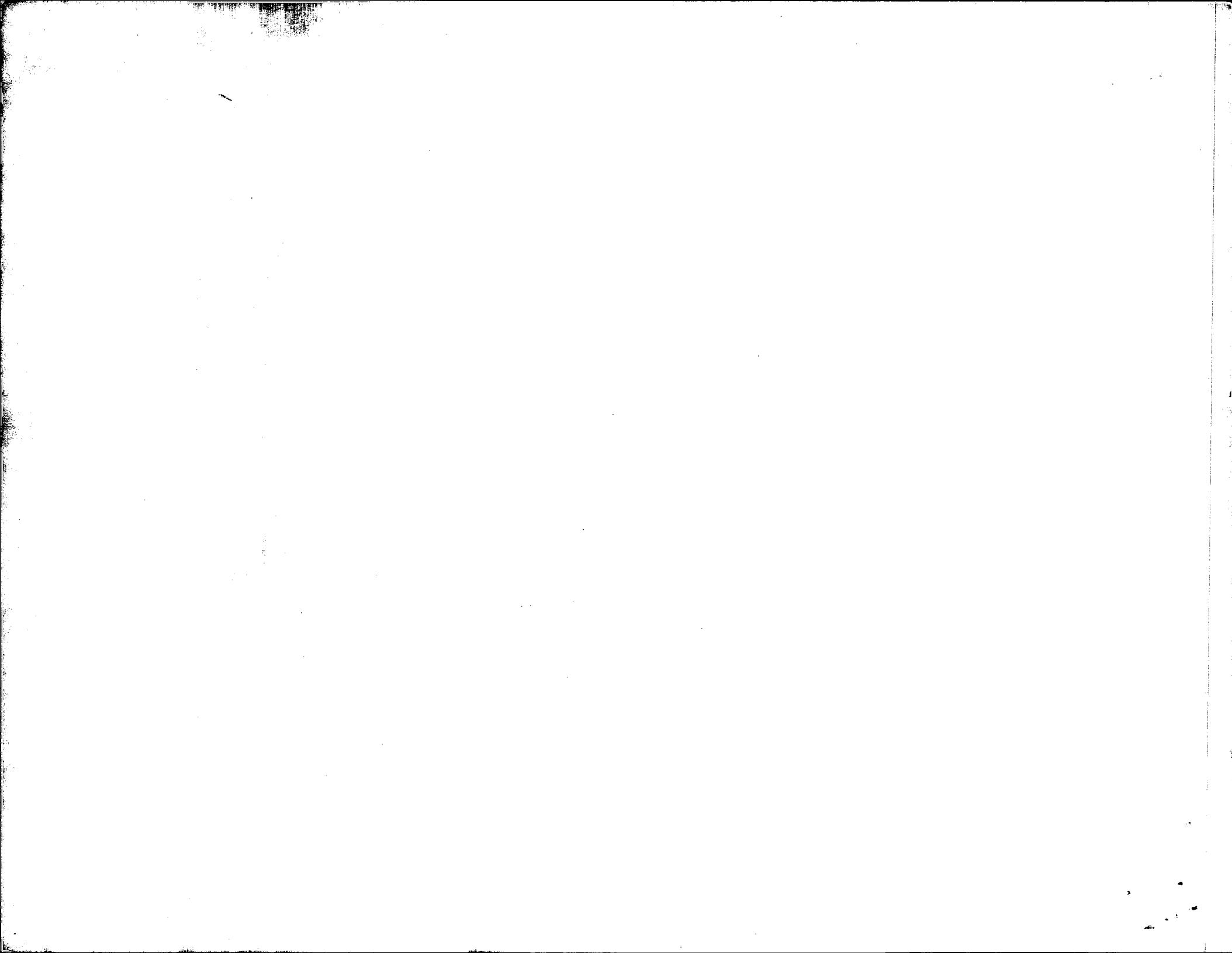
DESIGN JB		DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2000-111	REV. A SHEET 1 OF 1	
DATE 00.11.13		TITLE ASPIRATOR	SCALE 1:1	
A	00.11.13	NEW ISSUE		
A1	01.10.01	1.625 WAS 1.600		



NOTES:  
THIS PART MUST MATE WITH D2000-109  
MATERIAL: 1100-0 ALUMINUM (QQ-A-250/1) 0.063 THICK  
FINISH: NONE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Uffn. GERRY



Alcoa Metal Products  
480 Manheim Pike  
Lancaster Pa. 17601

# Certification of Test Results

P/N 970200

PO 38C880

SOLD TO

SHIP TO

CERT NO 000875996

DATE 4/23/2007

SKID NO 661032

SKID WGT 9,885

PAGE 1 OF 1

ORDER NO	105947	PO NO	43-62756								
ITEM NO	1	PART NO									
ALLOY	1100	TEMPER	O	FORM	COIL						
GAUGE	0.6300	WIDTH	48.3000	GENCTR	0.0000						

MILL FINISH  
NON ANODIZE QUALITY  
OUT: STANDARD MILL FINISH  
IN: STANDARD MILL FINISH  
NOT EMBOSSED

LOT: 034171 COIL: 801 DROP: 07TC187

INGOT	Si	Fe	Cu	Ni	Mg	Cr	Mo	Zn	Ti
0718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI

TAIL ULTIMATE STRENGTH 12.6 KSI

HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI

TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI

HEAD ELONGATION (G.L. = 2 IN) 32 %

TAIL ELONGATION (G.L. = 2 IN) 31.5 %

\* AS REPORTED BY SUPPLIER

MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB269 1100 C, AMS 4901H 1100 C

ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O

PAX CERTS: 714-736-4840

\*\* END OF CERTIFICATION \*\*

We hereby certify that, unless otherwise indicated, the material, as stated by this report, has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and the samples representative of the material and its composition. Also, none of the material is out of control containment in stainless alloys and neither of the any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

This document contains neither a stamp nor a signature from the U.S. Steel Quality Control or Technical Service department. Export Shipping Control Requirements: International traffic in arms prohibited.

Authorized By:

JERRY KREASY, LAB SUPERVISOR

Order No. 376276

Part:

Solid Copper & Brass Sales PO: 38C880

TR clerk signature

4/23/07/001

12:52 FAX



# Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7  
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

## INSPECTION REPORT

Date: Nov. 5/07  
Customer: Dart Aerospace  
Packing Slip: 34575

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2000109S	10	14G	n/a	✓	KL
D2000111S	10	14G	n/a	✓	KL

7/11/07

S6 Notes:

2 Boxes.

Material Certification Attached: YES

REFERENCE



Sieg's Manufacturing Ltd.  
6236 205 street, Langley BC, V2Y 1N7  
Phone: (604) 530-7455 Fax: (604) 530-7490

## Packing Slip

Packing Slip No.: 34575  
Date: 11/05/2007  
Page: 1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 4888	Sold By: KAULBARS, GERRY
Shipped By:	Ship Date: 11/06/2007
Tracking No.:	

Item No.	Unit	Description	Quantity
1	EACH	D2000109S OUTER FLANGE	
2	EACH	D2000111S INNER CORE	
<i>H109</i> <i>SS</i>			
<b>REFERENCE ONLY</b>			
Comment:			